

Work Order ID 65587

Thursday, January 20, 2011 10:19:20 AM



Page 1

DRAB GREEN

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-01-20 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2580	Rev.D DEO-D1								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG003

N/A HJ

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

11-2-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove bending marks

2- Prepare tube for swaging as per QSI 002

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

①

BB
11/02/24

1 8 2E4/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004
A/R□□□ Aluminum Rod

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start
expansion and finish with 1/2 x 18G to achieve dwg dimension.4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd
cap out of solution.

185

Drab Green(Ref:4.3.5.11)per QSI005 4.3.(Alum)

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:3:50
320°
11:20.

1 BL 11-3-7.

1 BL 11-3-7.

W/O:		WORK ORDER CHANGES					
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Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

1 0 92 11/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

0.00

Hand Finishing

Memo

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates

A/R ☐☐☐ Sikaflex-291 M116040 ☐☐☐Sikaflex expire date: 11/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive

A/R ☐☐☐ Sikaflex-291 M116040 ☐☐☐Sikaflex expire date: 11/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M1164021 0 11 03/08

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

0.00

S 11/03/09

220

Packaging

0.00



Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

0.00

PPR 67/03

230

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

mf

11-03-10

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Parent ID: D205-634-041

Parent Item Name: Replacement Skidtube




Start Date: 1/21/2011

Required Date: 2/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1  Spacer		Manufactured	No			140	Each	106.0000	20	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG	65529 66121 64608	106 106						11/03/01	
D2580-1  205 Skidtube bent detail		Manufactured	No			110	Each	2.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG	1365511 63051	1 1						11-2-23	
				ST046	59856	1							
D2576-3  Step (maching detail)		Manufactured	No			140	Each	62.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG	46661 52215	62 14 48							

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Page 2

Work Order ID: 65587

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 1/21/2011

Required Date: 2/10/2011

Start Qty: 1.00

Required Qty: 1.00

D2855 *drab green*

Manufactured No

200

Each

54.0000

1

1

Cap



yl 11/03/08

Location

Loc Qty

Loc Code

FP6

3

B65519

yl

56613

1

63634

2

ST026

51

50513

1

50770

28

51539

2

53791

20

AN3-5A

Purchased

No

200

Each

1,085.000

2

2

Bolt



yl 11/03/08

Location

Loc Qty

Loc Code

ST350

1085

115016

385

x2

115371

500

116632

200

AN960JD10L

NAS1149D0332J

Purchased

No

200

Each

0.0000

2

2

Washer



M 117010

yl 11/03/08

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Shop Packet Print

Page 2

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Parent Item Name: Replacement Skidtube

Start Date: 1/21/2011

Required Date: 2/10/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

1,628.000

50

50



Insert



11/03/08

Location

Loc Qty

Loc Code

FP

689

1116864

x50

115079

689

ST282

939

113238

17

115502

500

115581

422

AN3C4A

Purchased

No

200

Each

1,230.000

50

50



BOLT



11/03/08

Location

Loc Qty

Loc Code

ST350

1230

1116704

y50

115300

25

115936

8

116075

997

116590

200

AN960C10L

NAS1149C0332

Purchased

No

200

Each

25.0000

50

50



washer



11/03/08

Location

Loc Qty

Loc Code

ST245

25

1116304

y56

107534

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 1/21/2011

Required Date: 2/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-13 Manufactured No 200 Each 26.0000 1 1
Gasket
11/03/08

Location	Loc Qty	Loc Code
FP012	6	
61996	6	
FP014	20	
64070	20	

D3566-5 Manufactured No 200 Each 13.0000 1 1
Gasket
11/03/08

Location	Loc Qty	Loc Code
FP	12	366528
64789	12	
FP015	1	
63574	1	

D3566-1 Manufactured No 200 Each 6.0000 2 2
Gasket
11/03/08

Location	Loc Qty	Loc Code
FP015	6	366040
57715	1	
63573	5	

D3564-11 Manufactured No 200 Each 8.0000 1 1
Wearshoe
11/03/08

Location	Loc Qty	Loc Code
FP019	8	366554
62236	8	

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Required Date: 2/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200

Each

16.0000

1



Wearshoe



11/03/08

Location

Loc Qty

Loc Code

FP17

16

B65522

59660

1

61828

3

62229

12

x1

D3564-9

Manufactured No

200

Each

17.0000

1



Wearshoe



11/03/08

Location

Loc Qty

Loc Code

FP

1

55334

1

B66153

x1

FP019

1

61709

1

FP19

15

62238

15

D3564-5

Manufactured No

200

Each

22.0000

1



Wearshoe



11/03/08

Location

Loc Qty

Loc Code

FG

1

34806

1

B66148

x1

FP19

2

57525

1

58709

1

FP-19

19

63575

8

65058

11

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Start Date: 1/21/2011

Required Date: 2/10/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

200

Each

739.0000

16

16



O-Ring, 205 Skidtube



JH 1/10/08

Location

Loc Qty

Loc Code

FP

43

1361782

x16

55546

19

58191

12

59358

12

fpa

696

61762

696

D2594-1

drab green

Manufactured No

200

Each

235.0000

16

16



Plug, 205 Skidtube



JH 1/10/08

Location

Loc Qty

Loc Code

FP

183

42807

112

55002

71

FP14

52

1365512

x16

58434

15

62893

37

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *[Signature]***DEO ATTACHED**

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Losses

Diagram illustrating the grinding locations and features for the D2576-3 step:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- V_{14}

RELEASED
07-06-28

DEO ATTACHED

Technical drawing of a circular component with the following callouts and dimensions:

- #0.208**: Dimension for the central hole.
- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Instruction for drilling two locations.
- SEAL WITH SIKAFLEX-241/-291**: Instruction for sealing the component.
- AN3-SA BOLT (1)**: Callout for one bolt.
- AN96QJ10L WASHER (1)**: Callout for one washer.
- (2 PLACES)**: Dimension for two locations.
- D2855 CAP**: Callout for the cap.
- 0.40**: Dimension for the outer radius.

Diagram of a circular component with the following labels and instructions:

- D2579 SPACER**: Points to the top horizontal bar.
- D2596 WEB (REF)**: Points to the vertical central bar.
- AL57-1032-130 (REF) (TYP 50 PLACES)**: Points to the bottom horizontal bar.

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO #0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

[illegible]

Technical drawing of a skid assembly, showing side and cross-sectional views with dimensions and callouts.

Side View Dimensions:

- 0.5 (Radius at front end)
- 1.5 (Distance from front end to first vertical line)
- 1.5 (Distance between vertical lines)
- 0 (Distance from vertical line to centerline)
- 1.5 (Distance from centerline to next vertical line)
- 1.5 (Distance between vertical lines)
- 1.5 (Distance from vertical line to rear end)

Callouts and Notes:

- BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE
- BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE
- WELD AS PER DETAIL B
- REFER TO DETAIL C
- AN304A BOLT (1)
- AN960C10L WASHER (1)
- (50 PLACES)

Part Numbers:

- D3566-1
- D3566-5
- D3566-1
- D3566-13
- D3564-11
- D3564-5
- D3564-9
- D3564-13

Table:

DESIGN	DRAWN BY

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	DRAWN BY PH
	APPROVED H

TITLE	205 SKIDTUBE ASSEMBLY
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REV. D
SHEET 2 OF 3

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

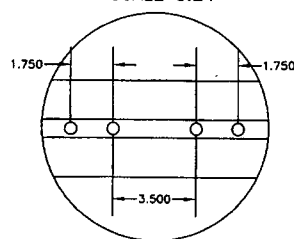
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

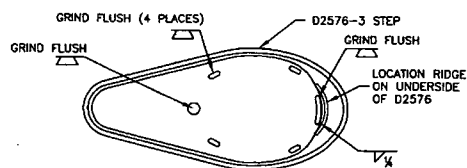
NOTE: Date & initial all entries

DETAIL E
SCALE 5:24



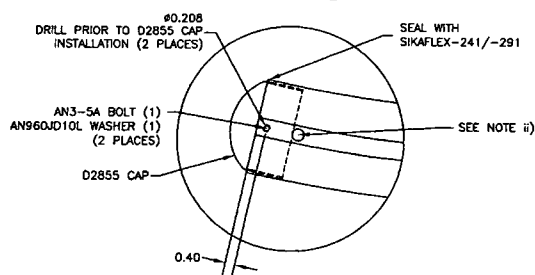
RELEASED
07-06-78

DETAIL F
SCALE 5:24

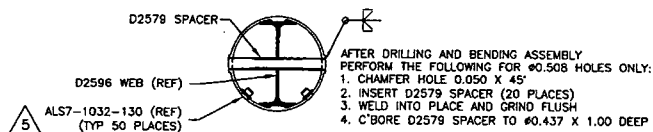


DEO ATTACHED

DETAIL G
SCALE 5:24



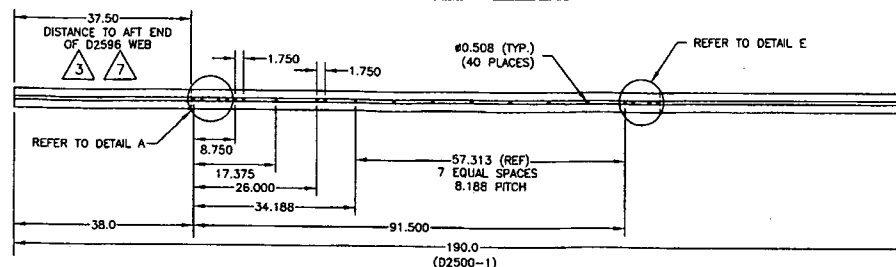
SECTION H-H
SCALE 5:24



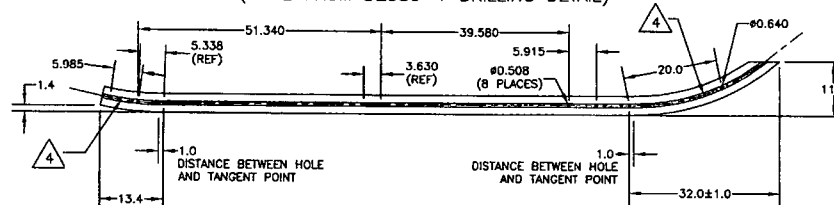
D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

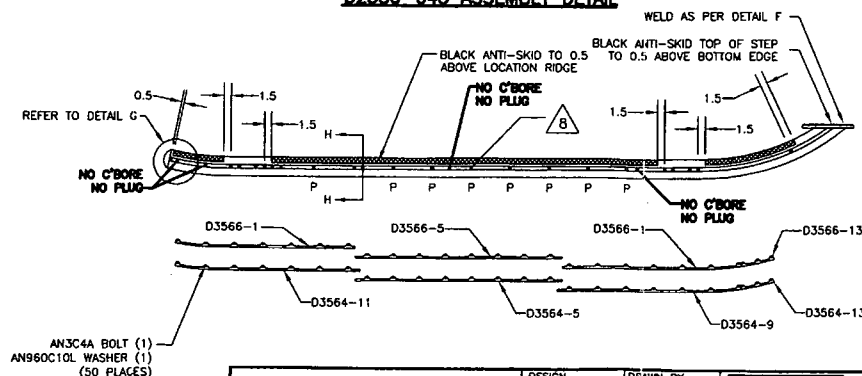
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
CHKD H	APPROVED H	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>R</i>	APPROVED <i>MP</i>		DE APPR. <i>H</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

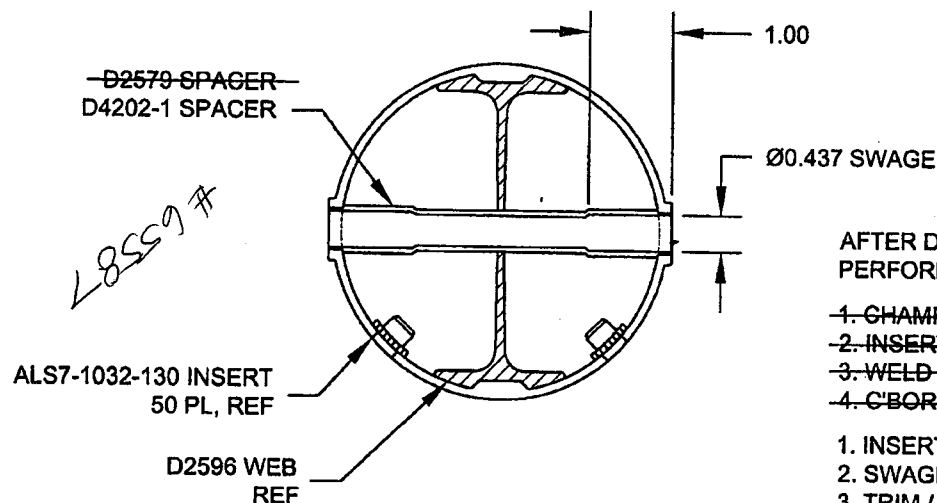
WAS

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
----	----	---------	--------

SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

RELEASED
2010-11-18
MP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section-C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries